

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018915**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (12AW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 051 in the (2G) horizontal position on longitudinal shear plate piece mark no. SEG3004V. The location was the complete joint penetration groove weld joining the longitudinal shear plate with the bottom panel of segment 12AW. The welder ID was 046704. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (12AE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 051 in the (2G) horizontal position on longitudinal shear plate piece mark no. SEG3004V. The location was the complete joint penetration groove weld joining the longitudinal shear plate with the bottom panel of segment 12AW. The welder ID was 047352. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

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OBG # TRIAL ASSEMBLY YARD (12AW-12BW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on side panel piece mark no. OBW12D. The location was the transverse splice weld joining segment 12AW and 12BW at work point W1 to W3. The welder ID was 040611. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on side panel piece mark no. OBW12D. The location was the transverse splice weld joining segment 12AW and 12BW at work point W1 to W3. The welder ID was 040656. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 008 in the (4G) overhead position on corner assembly side panel piece mark no. CA3012. The location was the transverse splice weld joining segment 12AW and 12BW at work point W1 to W3. The welder ID was 044551. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (12AE-12BE)

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 001 in the (1G) flat position on bottom panel piece mark no. OBE12B. The location was the transverse splice weld joining segment 12AE and 12BE at work point E3 to E4. The welder ID was 040367. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-BT-2231T-ESAB.

OBG # TRIAL ASSEMBLY YARD (12AE-12BE)

The QA Inspector observed the welding operation per the SMAW process on base metal in the (4G) overhead position on side panel. The location was the welding fixtures removed by means of grinding near transverse splice weld joint of segment 12AE and 12BE at bike path side. The welder ID was 050289. The welding was performed against critical welding repair report B-CWR2126. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on base metal in the (4G) overhead position on side panel. The location was the welding fixtures removed by means of grinding near transverse splice weld joint of segment 12AE and 12BE at bike path side. The welder ID was 040378. The welding was performed against critical welding repair report B-CWR2126. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

The QA Inspector observed the welding operation per the SMAW process on base metal in the (4G) overhead position on side panel. The location was the welding fixtures removed by means of grinding near transverse splice weld joint of segment 12AE and 12BE at bike path side. The welder ID was 040270. The welding was performed against critical welding repair report B-CWR2126. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

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For additional information please reference the pictures below:



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
